

RUST

Dart Aerospace Ltd.

Date: Thursday, 06/11/2008 12:52:34 PM  
 User: Chantal Lavoie

## Process Sheet

split

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: COVER		
Job Number	: 43233 4			Part Number	: D36414		
Estimate Number	: 12963			Drawing Number	: D3641 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 06/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: //	Type	: SMALL /MED FAB	Due Date	: 13/11/2008		
Previous Run	: 34544			Qty:	14	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD						

## Additional Product

SCH

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S032	6061-T6 Sheet 0.032"  
		.040
	Comment: Qty.: 0.8244 sf(s)/Unit Total : 12.3653 sf(s) MAT NOT PULLED M6061-T6 .032" THK sheet Batch: 109396	RB 8-11-7
2.0	WATER JET	FLOW WATER JET  
	Comment: FLOW WATER JET 1-Cut as per Dwg D3641 Dwg Rev: B Prog Rev: B	RB 8-11-7  
	2-Deburr if necessary	RB 8-11-7
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	RB 8-11-7
4.0	QC8	SECOND CHECK  
	Comment: SECOND CHECK	Job 8-11-07 (17)  
5.0	BRAKE NC	NC BRAKE  
	Comment: NC BRAKE Form as per Dwg D3641-1	SCRAPP  

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3641-4 PAR #: N/A Fault Category: Proc - Inv. Fab NCR: Yes No DQA:        Date: 08.11.13  
(D350-764-041) Resolution: Scrap Disposition: Scrap QA: N/C Closed:        Date: 08/11/20

NCR: 43233		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-11-07	2.0	Employee pulled a 0.040" material by mistake. Material measures 0.039 -> 0.037" after deburring. R.C: Did not measure the mat'l.	Initial AS1412	Acceptable this time only. Parts are <del>no</del> good. Cracked during bonding. I.d mat'l as scrap, and use for bond set ups. Material pulls cracks in the offset die.	AS 8-11-07 88/11/12	Initial AS1412 08-11-07	Initial AS1412	Initial AS1412

NOTE: Date &amp; initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 43233

Part Number: D36414

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

SCRAP

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-12

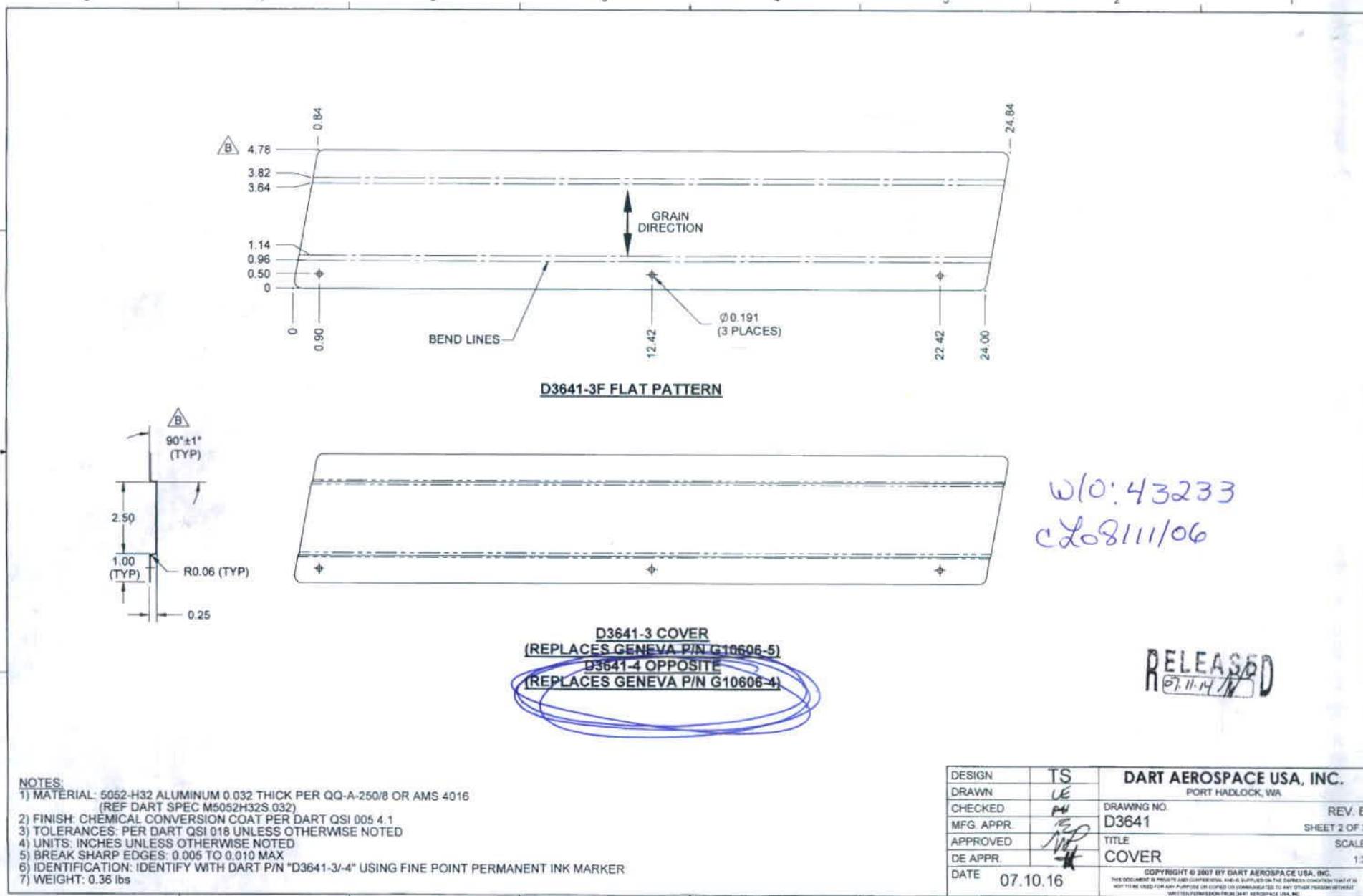
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DART AEROSPACE LTD	Work Order:	43233
Description: COVER	Part Number:	D3641-4
Inspection Dwg: D3641-4 Rev: B		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      X Prototype

Measured by:	BB
Date:	8-11-7

Audited by: / /  
Date: 09.11.07

Prototype Approval: NIA

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

